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D3072-2
Job Sheet 216144



Part No: D3072-2

Job Qty: 6 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/30/20

Job Tracking No:

Due Date: 12/14/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP B 02.01.18 Flat pattern created on dash 101. NG IPP Rev:C 08-02-26 now water jet DD verified by:LL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		12/12/20	0.17	0.32	Waterjet - Flow		on 20/12/10
110	QC 2	6 pcs		12/12/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/12/10
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	6	12/12/20	0.00 0.00	QC 8 - 12
	pcs				QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
130	Small Fab - 2 - B4B	6	12/12/20	0.00 0.28	Small Fab - 1 - B4B
	pcs				Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
					Small Fab - 8 - B4B
					Small Fab - 9 - B4B
					Small Fab - Various 1 - B4B
140	QC 5	6	12/12/20	0.00 0.00	QC 5 - 10
	pcs				QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49

DEC 11 2020 DAS 40

DEC 14 2020

					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	DAS
					QC 5 - 30	81
					QC 5 - 40	9-89
					QC 5 - 61	DEC 16 2020
					QC 5 - 81	
					QC 5 - 82	
150	Handfinish - 1-1 Chemical-B4B	6 pcs	12/12/20	0.00 0.17	Handfinish - 1 - 1 - B4B	3 FEB 16 / 12 / 2020
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 4 Black Sand - B4B	6 pcs	12/14/20	0.00 0.14	Powdercoat - 1 - B4B	
	1156 440.				Powdercoat - 2 - B4B	
	START: 11:40				Powdercoat - 3 - B4B	20-12-18
	OUT: 320°				Powdercoat - 4 - B4B	
	FINISH: 12:10				Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
170	QC 3	6 pcs	12/14/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	

				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	DEC 2 1 2020
				QC 3 - 19	DAS 40 9-89
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				QC 3 - 47	
180	Packaging 3-1 - Stock - B4B	6	12/14/20	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
190	QC 21 - SA	6	12/14/20	0.00 0.00	QC 21 - SA - 21
	pcs				QC 21 - SA - 70
					QC 21 - SA - 9

QC 21 - SA - 77

QC 21 - SA - 28

Part Op **100** - 1-Cut as per Dwg D3072 (D3072-101 flat pattern) Dwg Rev: AL Prog Rev: AL 2-Deburr if necessary
 Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - Small Fab - 1- deburr if necessary 2- Bend as per dwg D3072
140 - QC5- Inspect part completeness to step on W/O
150 - Chemical Conversion Coat per QSI005 4.1
160 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) - START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
170 - QC3- Inspect Part Finish
180 - Identify as per dwg & Stock Location: GA128
190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.090	5052-H32 .090 Sheet	.7002 sf (.1167 ea)	100-Waterjet - Flow - 1	FM131392

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M5052H32S.090	1	32	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.219Inches + 0.005 - 0.001	0.224 0.218	Diameter	<u>0.221</u>
2	Bracket	0.475Inches ± 0.010	0.485 0.465		<u>0.474</u>
3	Bracket	0.640Inches + 0.008 - 0.001	0.648 0.639	Diameter	<u>0.639</u>
4	Bracket	0.512Inches ± 0.010	0.522 0.502		<u>0.515</u>
5	Bracket	0.932Inches ± 0.010	0.942 0.922		<u>0.940</u>
6	Bracket	4.324Inches ± 0.010	4.334 4.314		<u>4.322</u>
7	Bracket	3.888Inches ± 0.010	3.898 3.878		<u>3.888</u>
8	Bracket	0.975Inches ± 0.010	0.985 0.965		<u>0.979</u>
9	Bracket	3.224Inches ± 0.010	3.234 3.214		<u>3.224</u>
10	Bracket	0.350Inches ± 0.010	0.360 0.340		<u>0.344</u>
11	Bracket	2.776Inches ± 0.010	2.786 2.766		<u>2.775</u>
12	Bracket	3.800Inches ± 0.010	3.810 3.790		<u>3.809</u>
13	Bracket	0.090Inches ± 0.010	0.100 0.080		<u>0.089</u>

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S319948



Part: D3072-2

Job No: 216144

Serial No/Batch: S319948

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA

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